

[illegible]

Page 1

Accept

[REDACTED]

Setup Start

Stop

**Cust Item ID:**

[REDACTED]

Customer:

Run Start

Date: 10-4-07

7 Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):**Date:**

Draw Nbr	Revision Nbr	
D3826	Rev B	

0.00

[illegible]

Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together
2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod
Batch: 71022.2

DD 10.04.12 (3) (6x)
SY 10/04/13 (3)

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

Cpl 10.04.73

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

810413

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 57432



April 7, 2010 8:16:46 AM



Page 2

Item ID: D3826-041 Accept  Setup Start 
Revision ID:
Item Name: Rib / Gusset Assembly Stop 
Start Date: 07/04/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 14/04/2010 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i> Memo	0.00 0.00		<i>SAD</i>		<i>(6)</i>			
				<i>10-04-13</i>					
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/04/14 *AS*
BS 10-4-13
(6)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 7, 2010 8:16:51 AM

Page 1

Work Order ID: 57432



Parent Item: D3826-041



Parent Item Name: Rib / Gusset Assembly

Start Date: 07/04/2010

Required Date: 14/04/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1 		Manufactured	No				Each	9.0000	6.0000			
Basket Rib											PD 10.04.08	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

9

B57433 5

55979

1

56472

8

1

D3929-041

Manufactured No



Gusset Assembly

Each

5.0000

6.0000



PD 10.04.08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

5

B57430 1

56180

5

5

D3929-042

Manufactured No



Gusset Assembly

Each

2.0000

6.0000



PD 10.04.08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

2

B57431 4

56181

2

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

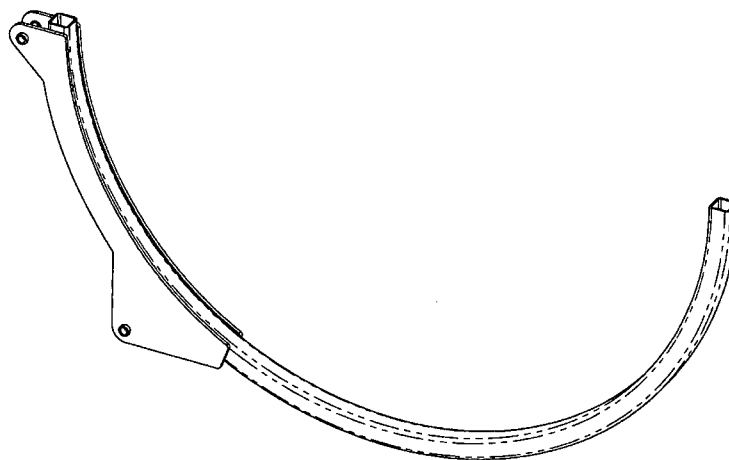
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57432

10-4-07

RELEASED
8/10/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>		
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B
TITLE **RIB/GUSSET ASSY** SCALE NTS
SHEET 1 OF 2

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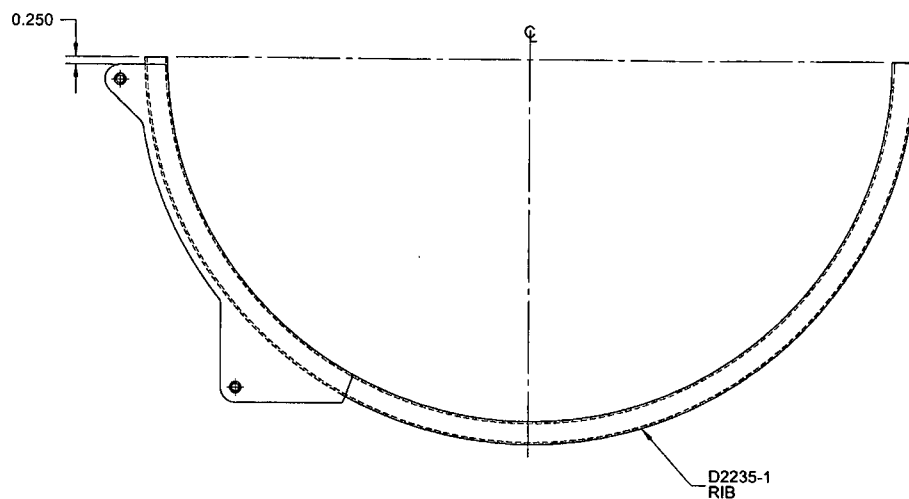
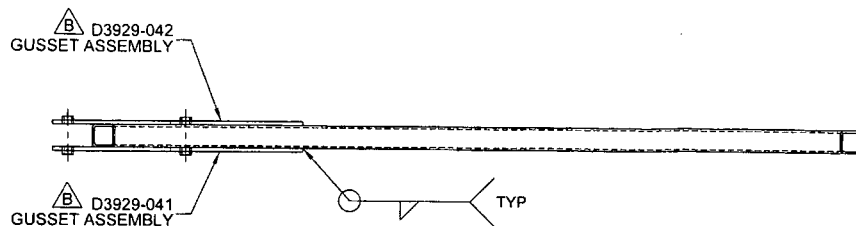
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3826-041 RIB/GUSSET ASSY

W/O 57430

RELEASED
9/24/12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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8 7 6 5 4 3 2 1

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